

SPLIT - 1

Dart Aerospace Ltd.

Date: Tuesday, 3/11/2008 10:28:32 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : N1 GEARBOX ACCESS PANEL KIT
Job Number : 37776--1	
Estimate Number : 12504	
P.O. Number :	
This Issue : 3/11/2008 S.O. No. :	Part Number : D3255042
Prsht Rev. : NC	Drawing Number : D3255 REV B
First Issue : 1/1	Project Number : N/A
Previous Run : 33604	Drawing Revision : B
Type : LARGE FAB ASSY	Material :
Written By : <u>[Signature]</u>	Due Date : 3/28/2008
Checked & Approved By : <u>[Signature]</u> 08 03 11	Qty: 2/4 Um: Each
Comment : Est Rev: C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32552	Panel
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Batch: B377887

2.0	D32553	Cap
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Batch: M121863

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

* purge weld

1-Weld as per Dwg D3255

A/R SS ROD Batch: M105524

2-Grind Welds Flush

4.0	DO NOT USE	WELD INSPECTION
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Comment: WELD INSPECTION

QC10
QC57
08/06/12 (x2)

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat Grey Bandtex (Ref. 4.3.5.6) as per QSI 005 4.3

M105642

M-1 08/06/12

30 min 2008

S.011 13.06

#1 319.3 F

#2 1337776-1

#3 D3255042

#4

Date: Tuesday, 3/11/2008 10:26:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 37776

Part Number: D3255042

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/12 (2)

7.0

D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Gasket

Batch:

B36779

CF 08/06/16

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-042 using Dow coming adhesive as per Dwg D3255

SB 08/06/26 (2)

A/R 736

DOW CORNING ADHESIVE

Batch:

M105846

CF 08/06/16 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/26 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 37429

AS 08/06/26 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2
D 08/06/27

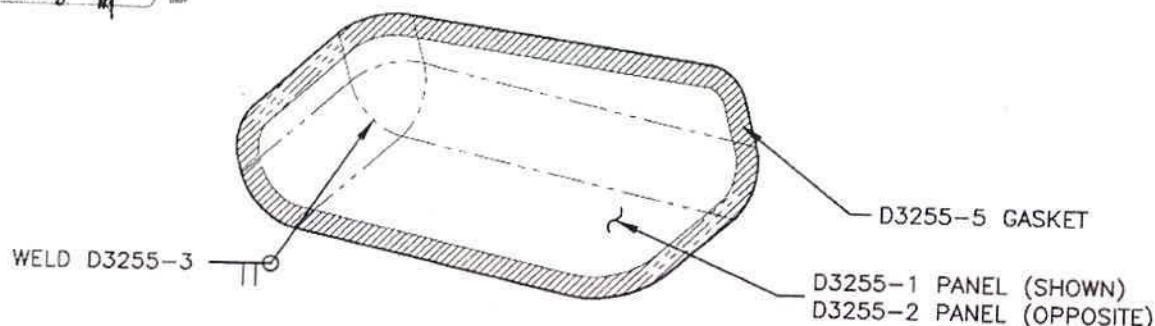
Job Completion



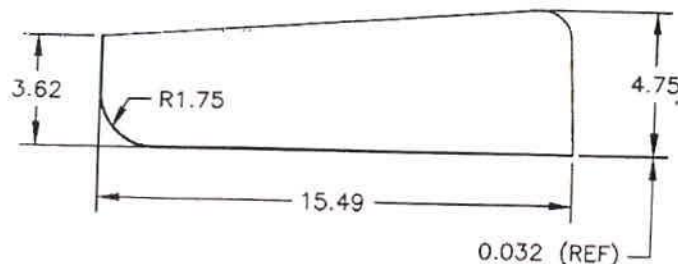
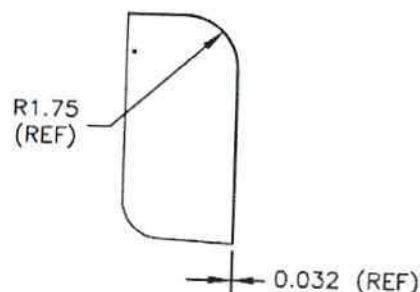
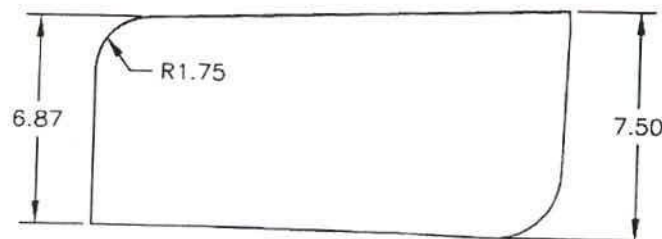
mf 08-06-27

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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NO. 37776

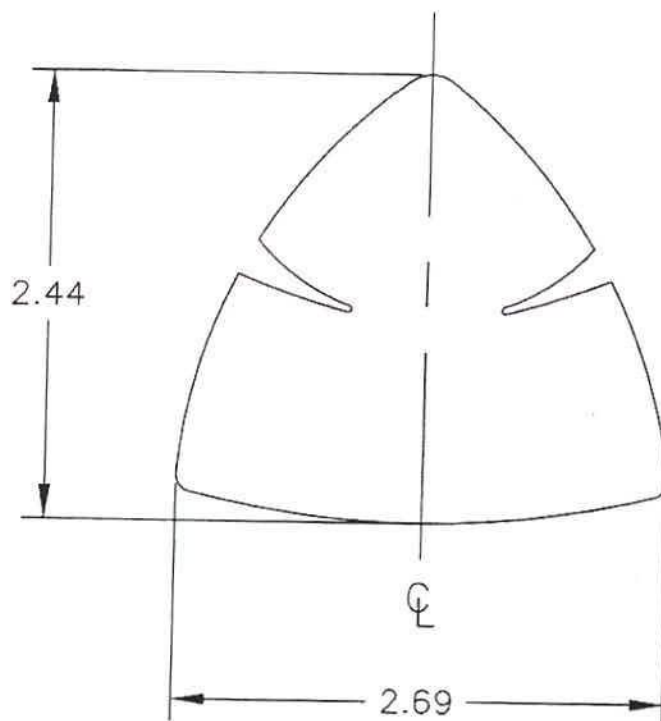
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CHECKED JP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

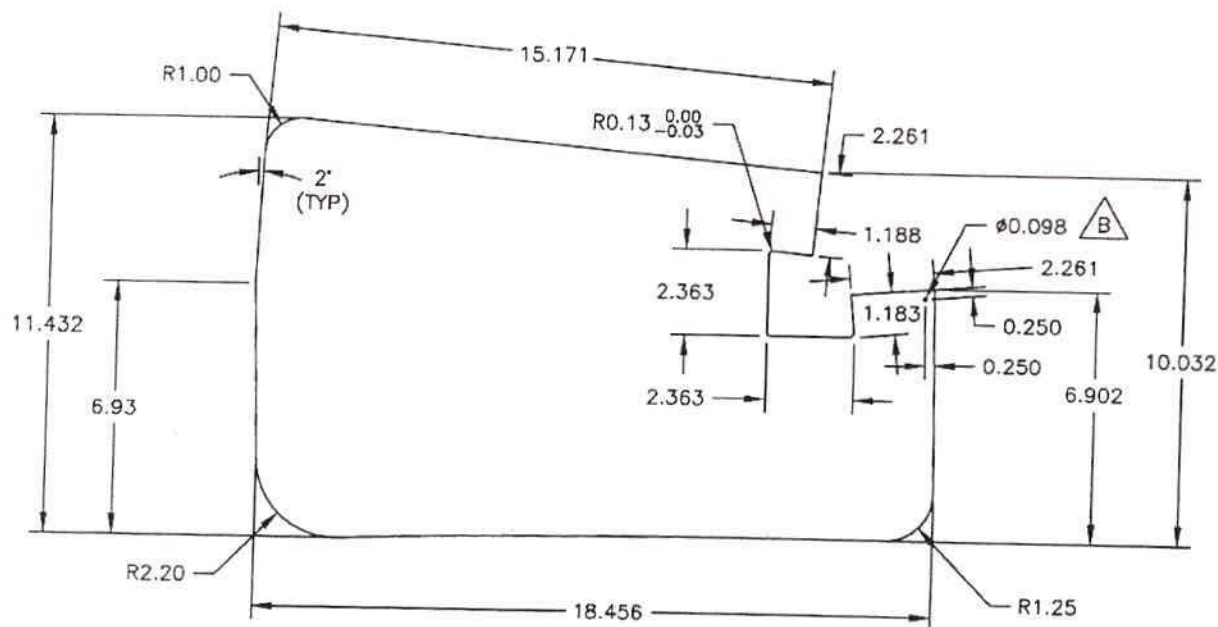
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CHECKED UP	APPROVED TF	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

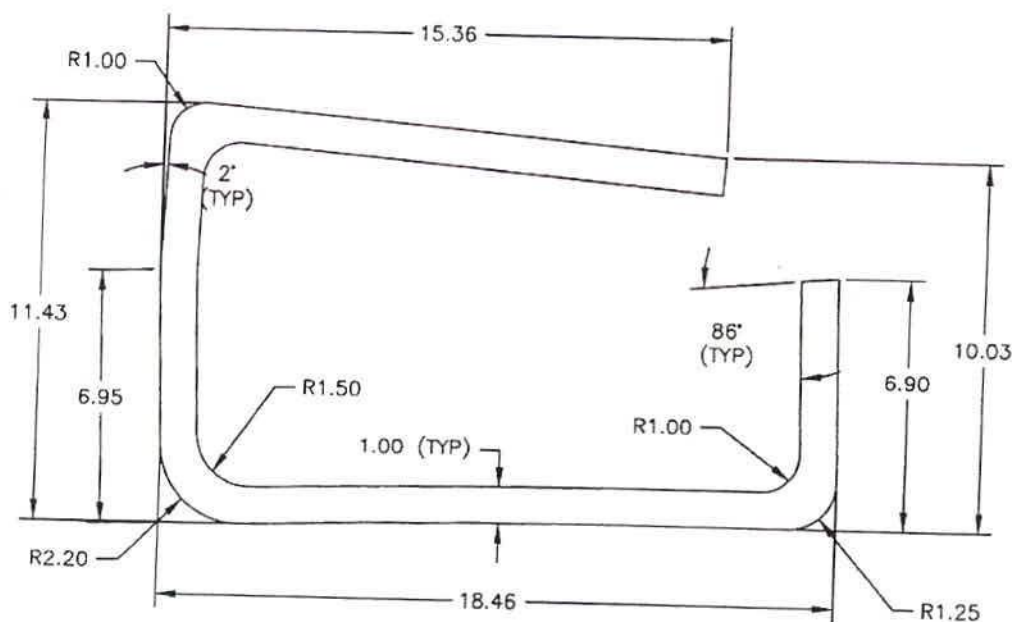
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CHECKED CP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18 JF**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIAL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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